

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002242**Date Inspected:** 06-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hu wei ing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Side Plates & Bottom Plates**Summary of Items Observed:**

The Quality Assurance (QA) Inspector,Mahlon Lindenmuth,arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates. This functions included but are not limited to the grinding of areas where temporary welds for strongbacks are located and bevel preparation for Complete Joint Penetration welds (CJP)on Side Plates and Bottom Plates.

QA Inspector, Lindenmuth, observed the welding of the complete joint penetration weld joining SP-043-001 to SP-055-001. The weld joint is located on Segment SEG020A-008. The material is identified as SPCM. The WPS used to support the welding of the joint is identified as WPS-B-T-223(2)1T. The welding processes used are FCAW and SAW including SMAW for the tack welds. QA Inspector Lindenmuth randomly monitored the SAW welding of the joint and recorded the following information:

Weld Process: SAW

Amperage:628

Voltage: 31

Travel Speed: 525mmpm

Welder/ID#: Wang ming (048296)

Backing material: Ceramic

Approximate Length of Joint: 550mm

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The joint was completed during the AM shift. The work observed by QA Inspector, Lindenmuth was found to generally comply with contract documents.

OBG Jig Fixture

ZPMC personnel were not observed performing any work on the OBG Jig Fixture. QA Inspector, Lindenmuth, observed the following members are positioned in the OBG Jig Fixture: Side Plates 3BE-C5 and 3BE-E7, Bottom Plate 3BE-D6.

Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lindenmuth, Mahlon	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
